

Work Order ID 71276

Friday, June 24, 2011 3:44:49 PM

Page 1

Item ID: D350-721-041

Accept

Revision ID:

Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011 Start Qty: 1.00

Required Date: 6/30/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 11-06-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-721-041CHG004

8/10/05

11-7-5

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/5 SF 12

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg IIN-D350-721 Attach Travelers:

2-Seal rivet Holes with Sika Flex before riveting

A/R 291 Sika Flex

Batch: M1116 945

Exp Date: 12/01/15

EP 11/07/05 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID, 71276

Friday, June 24, 2011 3:44:49 PM



Page 2

Item ID: D350-721-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

140

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

150

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/6/105

ⓧ

M/7/10

ⓧ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID, 71276

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Page 3

Item ID: D350-721-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-721-041 Location: _____ PPP Rev: <u>E</u>								
170 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/7/55

11/7/5

ME

11-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Friday, June 24, 2011 3:44:56 PM

Page 1

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011


Required Date: 6/30/2011

Start Qty: 1.00


Required Qty: 1.00

Comments: IPP Rev:D as per Rev B 05-11-21 JLM
IPP Rev:E 08-05-14 now @ chg 003 as per ECN1187 DD verified
by:JLM


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-15A  Bolt		Purchased	No				Each	375.0000	1	1			
---	--	-----------	----	--	--	--	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST357	200	
117423	200	
ST358	175	
117872	75	
118112	100	

AN4-20A  Bolt		Purchased	No			110	Each	577.0000	1	1			
---	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST359	577	
115936	77	
116419	200	
117514	300	

AN4-22A  Bolt		Purchased	No			110	Each	183.0000	1	1			
---	--	-----------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
ST359	183	
114784	35	
116419	49	
117313	99	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, June 24, 2011 3:44:56 PM

Page 2

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-7A Purchased No

110 Each

224.0000

2

2

(1x)

(1x)



Bolt



M115373

113226

Location

Loc Qty

Loc Code

ST356

224

117443

24

117514

200

AN5-17A Purchased No

110 Each

100.0000

4

4



Bolt



Location

Loc Qty

Loc Code

ST339

100

117619

50

117872

50

AN960JD416 NAS1149D0463J Purchased No

110 Each

0.0000

2

2



Washer



M117460

AN960JD416L NAS1149D0416J Purchased No

110 Each

33.0000

2

2



Washer



Location

Loc Qty

Loc Code

FP-B

29

110153

29

ST298

4

110153

4

AN960JD516 NAS1149D0563J Purchased No

110 Each

0.0000

4

4



Washer



M118206

AN960JD8 NAS1149DN832J Purchased No

110 Each

0.0000

2

2



Washer



M117316

11715

Friday, June 24, 2011 3:44:56 PM

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Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, June 24, 2011 3:44:56 PM

Page 3

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD9 *NAG1147DN 9490* Purchased No

110 Each

0.0000 32 32

Washer

AN970-4 Purchased No

110 Each

395.0000 4

Washer

Location

Loc Qty

Loc Code

ST342

383

117795

383

ST344

11

115936

11

ST349

1

116900

1

D2022-101 Manufactured No

110 Each

86.0000 2

Spacer

Location

Loc Qty

Loc Code

ST504

86

(69532)

26

69824

60

D2332-041 Manufactured No

110 Each

3.0000 1

Lid Prop Assembly 6.69" long

Location

Loc Qty

Loc Code

ST512

3

69600

3

Friday, June 24, 2011 3:44:57 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Friday, June 24, 2011 3:44:57 PM

Page 4

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2530

 Handle Weldment

Manufactured No

110 Each

11.0000

1



SP

Location

Loc Qty

Loc Code

ST506

1

68363

1

ST508

10

69318

10

D2535

 Spring

Manufactured No

110 Each

37.0000

2



SP

Location

Loc Qty

Loc Code

ST504

37

66764

9

69495

28

D2537

 Bushing

Manufactured No

110 Each

32.0000

2



2 SP

Location

Loc Qty

Loc Code

ST504

32

66972

2

69894

30

D2931

 Bumper

Manufactured No

110 Each

638.0000

2



2 11/15 SP

Location

Loc Qty

Loc Code

ST504

638

46064

638

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, June 24, 2011 3:44:57 PM

Page 5

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3320-041 Manufactured No

110

Each

11.0000

1



Webbing

Location

Loc Qty

Loc Code

ST483

11

46586

1

52376

10

D3324-041 Manufactured No

110

Each

0.0000

1



Basket Base Assembly

D3325-041 Manufactured No

110

Each

0.0000

1



Basket Lid Assembly

D3351-1 Manufactured No

110

Each

23.0000

1



Placard

Location

Loc Qty

Loc Code

ST048

23

46116

7

61577

16

MS20600-AD4W2 Purchased No

110

Each

190.0000

2



Rivet

Location

Loc Qty

Loc Code

ST321

190

116391

5

116471

4

116805

4

117601

1

117885

176

Friday, June 24, 2011 3:44:57 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, June 24, 2011 3:44:57 PM

Page 6

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS20600-AD4W3

Purchased

No

110

Each

933.0000

32



Cherry Rivets

Location

Loc Qty

Loc Code

ST321

800

111636

114

117505

500

117601

186

WA018

133

107939

133

MS21042L3

Purchased

No

110

Each

1,959.000

2



Nut

Location

Loc Qty

Loc Code

ST300

1959

116549

259

117441

800

117601

400

117885

500

MS21042L4

Purchased

No

110

Each

4,734.000

4



Nut

Location

Loc Qty

Loc Code

ST300

4734

117441

2445

117601

789

117885

1500

sf 32

32

2 sf

2

432

1116180

11715

sf

12

1116823

Friday, June 24, 2011 3:44:58 PM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, June 24, 2011 3:44:58 PM

Page 7

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3-16A

Purchased

No

140

Each

121.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST352

121

116419

21

117441

100

2

AN4-12A

Purchased

No

140

Each

160.0000

2

2



Bolt

Location

Loc Qty

Loc Code

ST357

160

115422

60

117508

100

AN4-14A

Purchased

No

140

Each

163.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST357

163

116914

4

117619

9

117872

150

4

AN960JD416

NAS1149D0463J

Purchased

No

140

Each

0.0000

28

28



Washer

11/24/60 11/7/38

Friday, June 24, 2011 3:44:58 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, June 24, 2011 3:44:58 PM

Page 8

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2230-1

Manufactured No

140 Each

202.0000

3

Lug

Location

Loc Qty

Loc Code

ST470

4

54755

4

ST476

198

67826

6

69179

92

69821

100

D2230-3

Manufactured No

140 Each

86.0000

4

Lug

Location

Loc Qty

Loc Code

Return 2010

4

62927

2

63544

2

ST476

82

53881

4

69820

78

D2732-030

Manufactured No

140 Each

16.0000

8

Rubber Cushion

Location

Loc Qty

Loc Code

ST402

16

69205

16

at 4x6 @ 3.00" long
Re Kit
Smealos

Friday, June 24, 2011 3:44:58 PM

Shop Packet Print

Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 9

Work Order ID: 71276

Parent Item: D350-721-041

Parent Item Name: Heli-Utility-Basket, Lightweight

Start Date: 6/24/2011

Required Date: 6/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3338-1
Mounting Lug

Manufactured No

140 Each

9.0000

Location

Loc Qty

Loc Code

MEZZ

9

48426

9

140 Each

4.0000

D3350-041
Strut Assembly

Manufactured No

Location

Loc Qty

Loc Code

ST271

4

52276

4

140 Each

4,734.000

MS21042L4
Nut

Purchased No

Location

Loc Qty

Loc Code

ST300

4734

117441

2445

117601

789

117885

1500

140 Each

986.0000

MS21042L5
Nut

Purchased No

Location

Loc Qty

Loc Code

ST300

986

116105

28

116548

260

117441

498

117591

100

117611

100

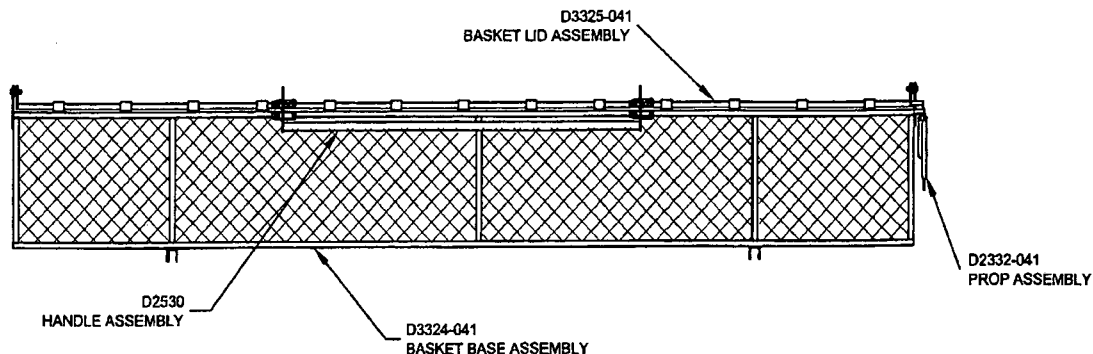
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

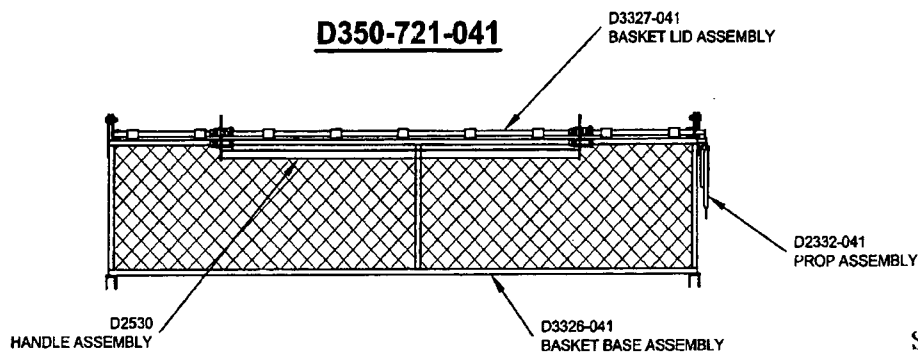
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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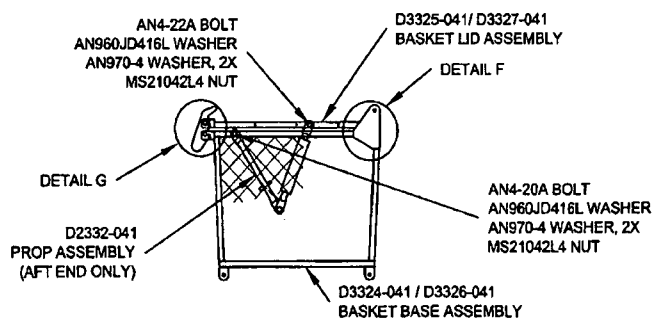
NOTE: Date & initial all entries



D350-721-041



D350-721-043



VIEW C-C:
PROP ARM DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71279
P/11-06-27

Figure 3 – Basket Replacement Parts
(D350-721-041/-043 Lightweight Heli-Utility-Basket™)

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Revision: **B**
Date: 10.06.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

6.0 PARTS LIST

REFERENCE ONLY

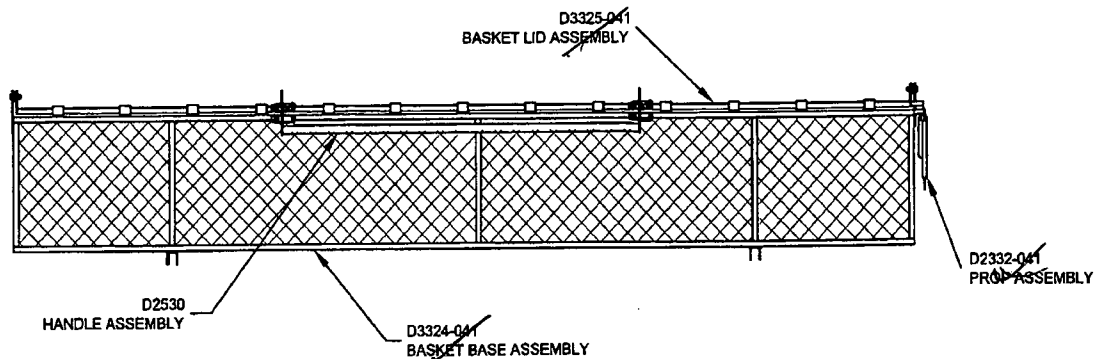
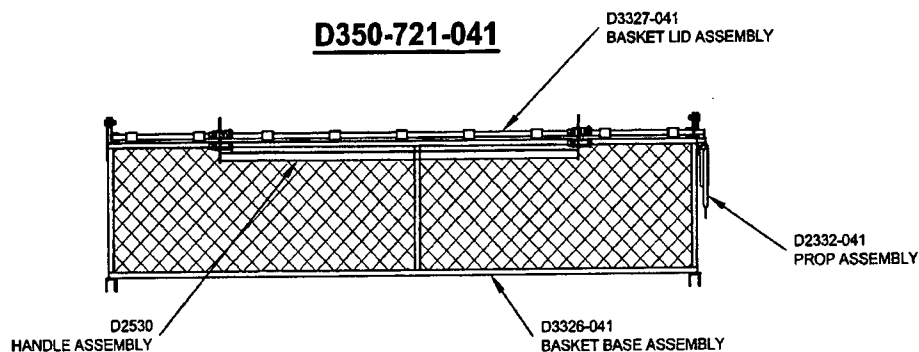
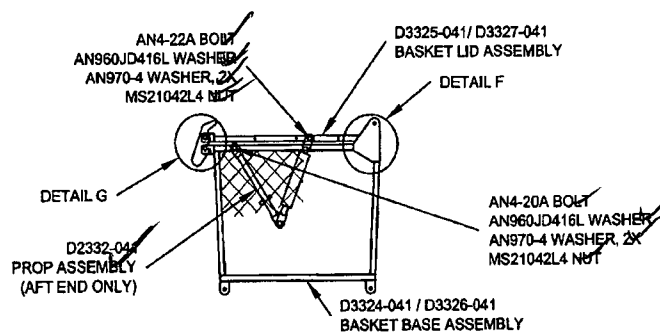
Qty -011	Qty -041	Qty -043	Qty -045	Qty -046	PART NUMBER	DESCRIPTION
X					D350-721-011	BASKET CLAMP KIT
	X				D350-721-041	LIGHTWEIGHT HELI- UTILITY-BASKET™
		X			D350-721-043	LIGHTWEIGHT HELI-UTILITY-BASKET™, SHORT VERSION
			X		D350-721-045	MAINTENANCE STEP, LH
				X	D350-721-046	MAINTENANCE STEP, RH
	1				D3324-041	BASKET BASE ASSEMBLY
	4				D3325-041	BASKET LID ASSEMBLY
		1			D3326-041	BASKET BASE ASSEMBLY
		1			D3327-041	BASKET LID ASSEMBLY
	2	2			D2022-101	SPACER
3	3	3			D2230-1	LUG
4	4	4			D2230-3	CLAMP
	1	1			D2332-041	PROP ASSEMBLY
	4	1			D2530	HANDLE ASSEMBLY
	2	2			D2535	SPRING
	2	2			D2637	BUSHING
8	8	8			D2732-030	RUBBER CUSHION
	2	2			D2031	BUMPER
	1	1			D3338-1	LUG
	2	2			D3350-041	STRUT
	1	1			D3351-1	LABEL
			1	1	D3436-041	CLAMP
			1		D3436-043	LH STEP
				1	D3436-044	RH STEP
	2	2			AN3-16A	BOLT
	2	2			AN4-7A	BOLT
	2	2			AN4-12A	BOLT
	4	4			AN4-14A	BOLT
8	8	8			AN4-15A	BOLT
			4	4	AN4-16A	BOLT
	1	1			AN4-20A	BOLT
	1	1			AN4-22A	BOLT
	4	4			AN5-17A	BOLT
			8	8	AN960-416	WASHER
16	20	30			AN960JD416	WASHER -2
	2	2			AN960JD446L	WASHER
	4	4			AN960JD516	WASHER
	2	2			AN960JD8	WASHER
	4	4			AN970-4	WASHER
			4	4	MS20365-428	NUT
	2	2			MS20600AD4W3	RIVET
	2	2			MS21042L3	NUT (OR MS21042-3)
8	14	18			MS21042L4	NUT (OR MS21042-4) -2-2-
	4	4			MS21042L5	NUT (OR MS21042-5)

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Revision: B

Date: 10.06.15

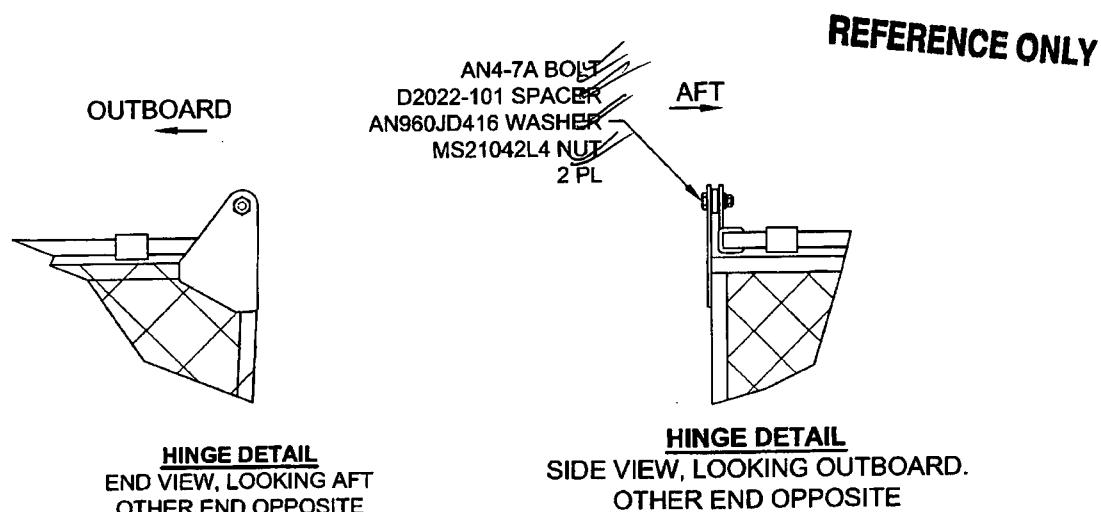
**D350-721-041****D350-721-043**

VIEW C-C:
PROP ARM DETAIL

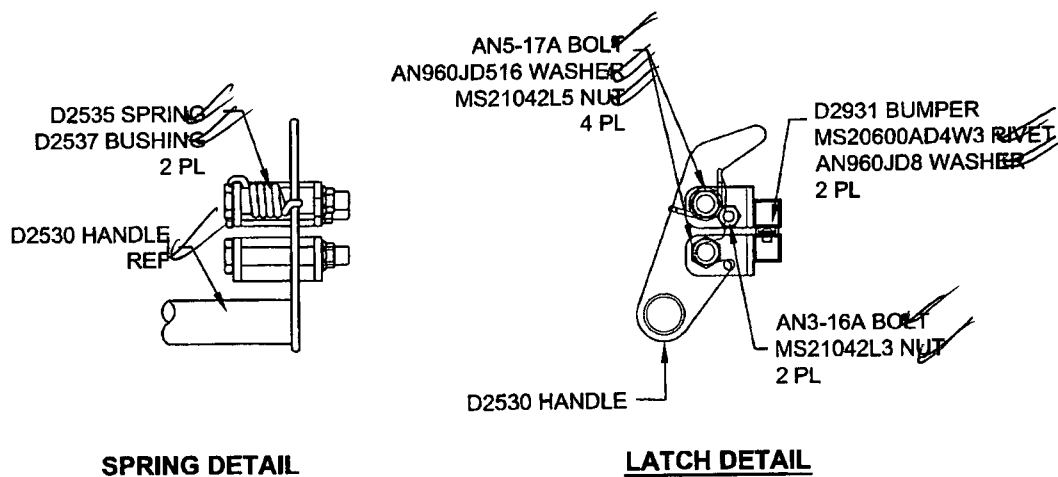
Figure 3 – Basket Replacement Parts
(D350-721-041/-043 Lightweight Heli-Utility-Basket™)

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DETAIL F:
HINGE



DETAIL G:
HANDLE WELDMENT

Figure 4- Basket Replacement Parts
(D350-721-041/-043 Lightweight Heli-Utility-Basket™)

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